

1

Work Order ID 132065

Friday, April 24, 2015 9:16:18 AM

132065

Page 1

Item ID: D206-642-611

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH,High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 150424

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D206-642

Q



MCS 1504-27

100 Document Control

0.00

100

DAS
26
9-89

14

APR 30 2015

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-611 CHG006

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging



APR 28 2015

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
6
9-89



MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :																			

Work Order ID 132065

Friday, April 24, 2015 9:16:18 AM

132065

Page 2

Item ID: D206-642-611

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH,High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-611

Location: 073

PPP Rev: _____

MAY 12 2015

DAS
989

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

MAY 12 2015

MCS

MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐							

Picklist Print

Friday, April 24, 2015 9:16:23 AM

Page 1

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.10.27 Revised pick list KJ/EC
 IPP Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:ec
 IPP Rev:D 09-01-06 update part list DD verified by:EC IPP REV:E
 13.09.05 CHG005/ECN13-634 DD VERF:JLM IPP REV:F 14.04.28
 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0363R		Purchased	No			110	Each	468.0000		6			

NAS1149C0363R

Washer

Location	Loc Qty	Loc Code
FP001	75	
114742	75	
GA	181	
m130673	181	
ST271	212	
m130673	212	

D206-642-641

Manufactured No

110 Each

1.0000

D206-642-641

Repl. Skidtube,High Gear,Std Wearplates, Fits LH or RH, DART Tri-Bag Float Comp.

Location	Loc Qty	Loc Code
FG	1	
113627	1	
110	Each	12.0000

D206-651-041

Manufactured No

110 Each

12.0000

D206-651-041

206 A/B GHW

Location	Loc Qty	Loc Code
FG	1	
79558	1	
PKG012	11	
112977	3	
114414	8	

DAS
02
9-89

DAS
27
9-89

DAS
02
9-89

APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Picklist Print

Friday, April 24, 2015 9:16:23 AM

Page 2

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2665-1

Manufactured No

110

Each

9.0000

2 2

**

DAS
02
9-89

D2665-1

Saddle, LH Fwd Aft Out

DAS
26
9-89

Location

Loc Qty

Loc Code

ST402

9

112573

2

113844

3

120551

4

2

D2666-1

Manufactured No

110

Each

9.0000

2 2

**

68-6
Z0
DAS

D2666-1

Saddle, LH, Fwd, Aft, In

DAS
26
9-89

Location

Loc Qty

Loc Code

ST402

9

109550

4

113180

1

120440

4

2

AN3C41A

Purchased No

110

Each

246.0000

8 2 8

**

DAS
02
9-89

AN3C41A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

122843

5

124975

1

m130081

4

ST338a

175

131651

75

m128491

25

m131367

75

ST347

61

m131856

61

8

Friday, April 24, 2015 9:16:23 AM

Shop Packet Print

APR 3 2 2015

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Friday, April 24, 2015 9:16:23 AM

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube L.H.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

520.0000

16

D2652

Bushing

**

DAS
02
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	45	
31985	45	
ST009	36	
129992	36	
ST012a	439	
123711	32	
124422	3	
129992	0	
129993	301	
131087	103	

16

MS21043-3

Purchased

No

110 Each

985.0000

17

MS21043-3

Nut

**

DAS
02
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP001	73	
m130673	73	
GA	367	
m130673	15	
m131677	352	
ST304	465	
m131340	465	

17

APR 32 2015

Friday, April 24, 2015 9:16:24 AM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, April 24, 2015 9:16:24 AM

Page 4

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH,High Gear,Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN5C11A

Purchased

No

110

Each

168.0000

4

4

AN5C11A

Bolt

**

DAS
02
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG	4	
103715	4	
ST286A	150	
M126105	49	
M127817	1	
M131305	50	
M131624	50	
ST338	12	
M131139	12	
ST339	2	
M127817	2	

4

Handwritten signature/initials

AN5C32A

Purchased

No

110

Each

177.0000

4

4

AN5C32A

BOLT

**

DAS
02
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG	4	
18918	4	
ST286A	100	
131650	100	
ST336	73	
m131152	23	
m132102	50	

4

Handwritten signature/initials

APR 32 2015

Friday, April 24, 2015 9:16:24 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, April 24, 2015 9:16:24 AM

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

110

Each

222.0000

4 4

MS21043-5

Nut

**

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

77

116548

77

ST304

125

m131317

25

m132123

100

110

Each

383.0000

8 8

NAS1149C0532R

Purchased

No

NAS1149C0532R

WASHER

**

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

321

m128537

121

m131624

200

110

Each

680.0000

24 24

D3672-7

Manufactured

No

D3672-7

Washer, Phenolic

**

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

45

124419

36

93370

9

ST055

49

120476

49

ST064A

586

124419

86

129987

500

APR 32 2015

Friday, April 24, 2015 9:16:24 AM

Shop Packet Print

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, April 24, 2015 9:16:24 AM

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

586.0000

12 12

AN4C6A

Bolt

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST312A

320

m131320

20

m131618

300

ST345

252

m130716

52

m131410

200

NAS1149C0432R

Purchased

No

110

Each

3,543.000

24 24

NAS1149C0432R

WASHER

**

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

2206

m125807

476

m131467

1730

ST271

1337

m131452

1337

24
X/O

DAS
02
9-89

DAS
02
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

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Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH,High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

110

Each

642.0000

24 24

D3672-3

Washer, Phenolic

**

DAS
02
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

153

127875

50

129916

40

84432

11

89273

52

FP001

14

107316

14

ST055

475

121577

40

129916

435

110

Each

1,079.000

12 12

**

MS21043-4

Purchased

No

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

367

m128798

367

ST304

672

m128818

34

m131697

638

DAS
26
9-89

DAS
02
9-89

APR 3 2 2015

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Picklist Print

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Page 8

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH,High Gear,Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

110

Each

256.0000

2

AN6C44A
Bolt

**

DAS
02
9-89

Location	Loc Qty	Loc Code
FG	2	
103964	2	
FP001	5	
m130863	4	
m131367	1	
ST286A	188	
131649	100	
m130863	13	
m131856	21	
m131946	54	
ST332	11	
m130863	11	
ST333	50	
m131151	50	

DAS
26
9-89

2
40

MS21043-6

Purchased

No

110

Each

26.0000

2

MS21043-6
NUT

**

DAS
02
9-89

Location	Loc Qty	Loc Code
FG	20	
103693	20	
FP001	6	
131618	4	
m130325	2	

DAS
26
9-89

m132164

2

DAS
27
9-89
APR 28 2015

APR 30 2015

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Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH,High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

110

Each

600.0000

10

10

D2712

Set Screw

**

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

95

115155

93

121858

2

ST012a

450

127910

250

130024

200

NAS1149C0663R

Purchased No

110

Each

83.0000

4

4

NAS1149C0663R

Washer

**

DAS
02
9-89

Location

Loc Qty

Loc Code

ST271

83

m126221

83

D2884

Manufactured No

110

Each

18.0000

2

2

D2884

Saddle Spacer

**

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

10

29453

10

ST013

8

113032

8

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Ricklist Print

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Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH,High Gear,Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2885 Manufactured No

110 Each

28.0000

2

D2885

Saddle Spacer

**

DAS
02
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	10	
29199	10	
ST013	18	
110795	1	
121615	17	

AN3C36A Purchased No

110 Each

240.0000

6

AN3C36A

Bolt

**

DAS
02
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	7	
101261	4	
122204	2	
m131367	1	
FP001	48	
m131856	48	
ST338a	130	
131651	80	
m130874	50	
ST347	55	
m131367	55	

MS21250-03004 Purchased No

110 Each

31.0000

6

MS21250-03004

HIGH STEEL BOLT

**

DAS
02
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
ST298	31	
M128429	6	
M128798	25	

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Picklist Print

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Page 11

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH,High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

4,072.000

18

18

NAS1149C0332R
WASHER

**

DAS
02
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FP001

2174

123248

34

m130325

2140

GA

734

m131618

734

ST260a

1140

m131697

1140

ST271

24

m131340

24

D3672-1

Manufactured

No

110

Each

724.0000

18

18

D3672-1

Washer, Phenolic

**

DAS
02
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

242

113581

242

ST055

472

120116

3

127322

469

APR 3 2 2015

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Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3396-3

Manufactured No

110 Each

26.0000

2 2

D3396-3

Bushings

DAS
26
9-89

**

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

2

26772

2

ST037

24

123680

24

AN5C35A

Purchased

No

110

Each

100.0000

**

DAS
02
9-89

AN5C.35A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

ST286A

84

M129871

84

ST336

16

M128687

16

AN5C13A

Purchased

No

110

Each

105.0000

**

DAS
02
9-89

AN5C.13A

BOLT

DAS
26
9-89

Location

Loc Qty

Loc Code

ST286A

75

M130466

75

ST338

30

M127363

30

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Page 13

Work Order ID: 132065

132065

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH.High Gear.Std Wearplates (2.5" Bolt Spacing) Tri-Bag Float Comp.

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN5C7A

Purchased

No

110

Each

269.0000

**



4

AN5C7A

BOLT

**DAS
02
9-89**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

2

19185

2

ST286A

150

m131320

150

ST338

117

m131139

17

m132123

100

APR 32 2015

4.9 206A/B HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE) APR 30 2015

ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -655	QTY -649	PART NUMBER	DESCRIPTION
	X							D206-642-611	SKIDTUBE INSTALLATION, LH
		X						D206-642-612	SKIDTUBE INSTALLATION, RH
			X					D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X				D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X			D206-642-641	SKIDTUBE
						X		D206-642-655	WEARSHOE KIT (REPLACES -645 KIT)
							X	D206-642-649	RUN-ON LANDING WEARPLATE KIT
	1	1	1	1				D206-651-041	* 206 GHW ADAPTER ⁽¹⁾
1					1			D3288-041	SKIDTUBE ASSEMBLY
3					1			D2646	* AFT CAP ⁽¹⁾
4					2			AN3C4A	* BOLT ⁽¹⁾
5A					2			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1					D2665-1	SADDLE, FWD OUT, LH
6		1		1				D2665-2	SADDLE, FWD OUT, RH
7	1		1					D2666-1	SADDLE, FWD IN, LH
7		1		1				D2666-2	SADDLE, FWD IN, RH
8	1							D2665-1	* SADDLE, AFT OUT, LH
8		1						D2665-2	SADDLE, AFT OUT, RH
8			1					D2667-1	SADDLE, AFT OUT, LH
8				1				D2667-2	SADDLE, AFT OUT, RH
9	1							D2666-1	SADDLE, AFT IN, LH
9		1						D2666-2	SADDLE, AFT IN, RH
9			1					D2668-1	SADDLE, AFT IN, LH
9				1				D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8				AN3C41A	* BOLT
11	16	16	16	16				D2652	* BUSHING
12A	8	8	8	8				MS21043-3	* NUT
12B	16	16	16	16				D3672-7	* WASHER (REPLACES NAS1515H5)
13	4	4	4	4				AN5C7A	* BOLT
14	4	4	4	4				AN5C11A	* BOLT
14A	4	4	4	4				AN5C32A	* BOLT
14B	4	4	4	4				MS21043-5	* NUT
15A	8	8	8	8				NAS1149C0532R	* WASHER (OR AN960C516L)
15B	8	8	8	8				D3672-7	* WASHER (REPLACES NAS1515H5L)
16	12	12	12	12				AN4C6A	* BOLT
17A	24	24	24	24				NAS1149C0432R	* WASHER (OR AN960C416L)
17B	24	24	24	24				D3672-3	* WASHER (REPLACES NAS1515H4L)
18	12	12	12	12				MS21043-4	* NUT
20A					7	7		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1		D4956-15	* WEARSHOE ⁽¹⁾ (REPLACES D3535-15 + D3536-15)
23A					1	1		D4956-21	* WEARSHOE ⁽¹⁾ (REPLACES D3535-21 + D3536-21)
24A					1	1		D4956-41	* WEARSHOE ⁽¹⁾ (REPLACES D3535-41 + D3536-41)
25A					1	1		D4956-35	* WEARSHOE ⁽¹⁾ (REPLACES D3535-35 + D3536-35)
26A					64	64	8	AN3C4A	* BOLT ⁽¹⁾
26B					64	64	8	NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C					64		8	ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2				AN6C44A	* BOLT
29A	2	2	2	2				MS21043-6	* NUT
29B	4	4	4	4				NAS1149C0663R	* WASHER (OR AN960C616)
34					1			AN4C5A	* BOLT
35					1			NAS1149C0463R	* WASHER (OR AN960C416)
36					1			D3413-1	* RING
37	10	10	5	5				D2712	* SET SCREW
38	2	2	2	2				D2884	* SADDLE SPACER
39	2	2	2	2				D2885	* SADDLE SPACER

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ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -655	QTY -649	PART NUMBER	DESCRIPTION
50	6	6	6	6				AN3C36A	BOLT
51	6	6	6	6				MS21250-03004	HIGH STRENGTH STEEL BOLT
52	18	18	18	18				NAS1149C0332R	WASHER (OR AN960C10L)
53	18	18	18	18				D3672-1	WASHER (REPLACES NAS1515H3L)
54	9	9	9	9				MS21043-3	NUT
55	2	2	2	2				D3396-3	SPACER
56A	1	1	1	1				AN5C35A	BOLT
56B	1	1	1	1				AN5C13A	BOLT
57	6	6	6	6				NAS1149D0363J	WASHER (OR AN960JD10)
60	12	12	12	12				D3683-1	INSERT ⁽¹⁾
61	12	12	12	12				NAS1149C0332R	WASHER ⁽¹⁾ (OR AN960C10L)
62	12	12	12	12				MS27039C1-05	SCREW ⁽¹⁾ (or AN3C3A BOLT)
80							1	D4370-041	FWD WEARPLATE ASSY
81							1	D4370-043	AFT WEARPLATE ASSY
82A							1	D4383-1	WEARPAD
82B							1	D4383-3	WEARPAD
83							16	D3873-3	BUSHING
85							6	D3275-1	SPACER
86A							2	AN3-37A	BOLT
86C							6	AN3-36A	BOLT
87							8	MS21043-3	NUT

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D3286-041 ASSEMBLY ABOVE
⁽²⁾ MAY BE REQUIRED ON -613/-614 INSTALLATIONS OR DART CROSSTUBES
⁽³⁾ NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

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